

Work Order ID 71855

Wednesday, July 13, 2011 11:00:23 AM



Page 1

Item ID:	D3417-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Washer					
Start Date:	7/14/2011	Start Qty: 40.00		Cust Item ID:		
Required Date:	7/28/2011	Req'd Qty: 40.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>MF</u>	Date: <u>11-07-13</u>	Tooling:	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3417	Rev E								
100	Hardinge CNC LATHE SMALL	0.00							
	Doosan	0.00							
Doosan Lathe	Memo 1-Turn as per Folio FA761 Rev: <u>28</u> & Dwg D3417 Rev: <u>E</u> 2-Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								
120	QC8- Inspect parts - second check	0.00							
	QC	0.00							
Quality Control	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

- NOTE: Date & initial all entries

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Item ID: D3417-5

Accept

Revision ID:

Item Name: Washer

Start Date: 7/14/2011 Start Qty: 40.00

Required Date: 7/28/2011 Req'd Qty: 40.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: **S3**

0.00

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/7/14 **41**11/7/15 **MF**

11-07-15

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Picklist Print

Wednesday, July 13, 2011 11:00:20 AM

Page 1

Work Order ID: 71855



Parent Item: D3417-5



Parent Item Name: Washer

Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A ☐ New issue ☐ 08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.2500		Purchased	No			110	f	16.1340	0.0296	1.246316			
DELIN ROUND BAR 1.25"													

Location

MAT055

114586 ✓

Loc Qty

16.134

16.134

Loc Code

29 11.7.14

1.666

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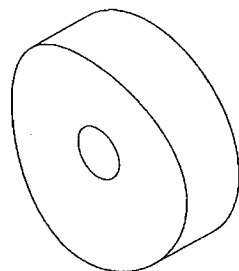
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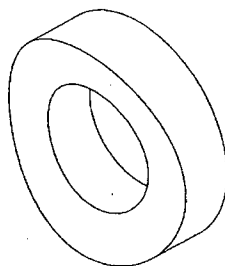
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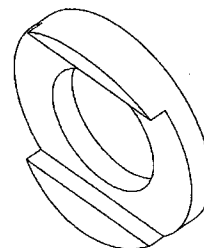
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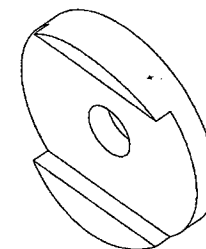
D3417-1 WASHER



D3417-3 WASHER

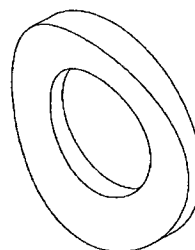


D3417-5 WASHER



D3417-7 WASHER

71855



D3417-9 WASHER

RELEASED
2010-09-15
wlf

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
D3417-3, 0.010 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs

F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.08.30
D	ADD -S WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
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DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT ITS USE IS LIMITED TO THE PURPOSE FOR WHICH IT WAS SUPPLIED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

Dart Aerospace Ltd

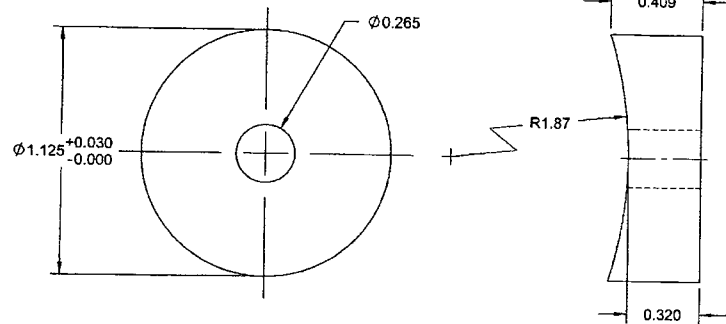
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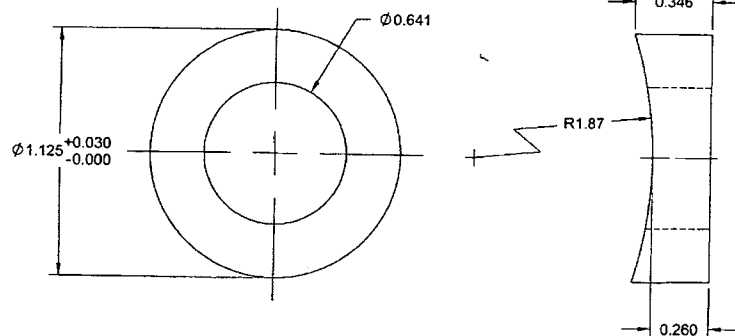
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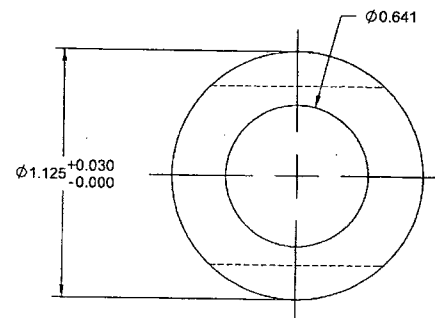
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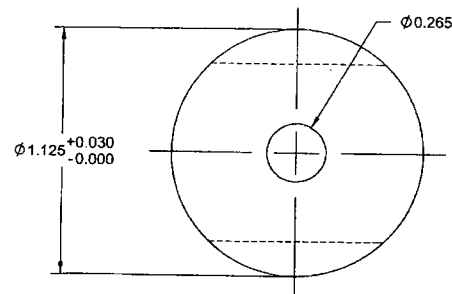
D3417-1 WASHER



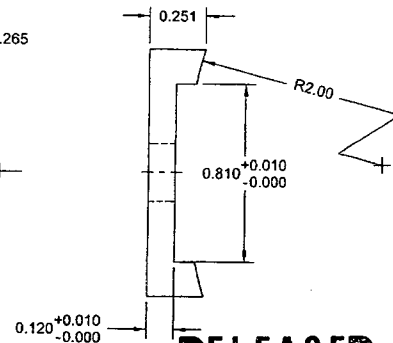
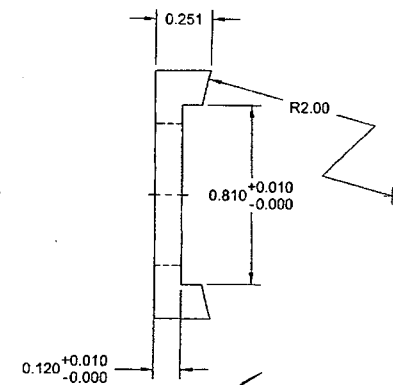
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



RELEASED
2010-09-15

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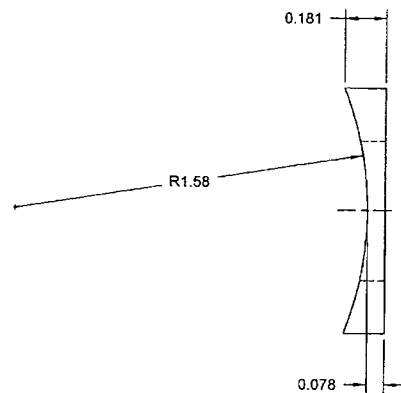
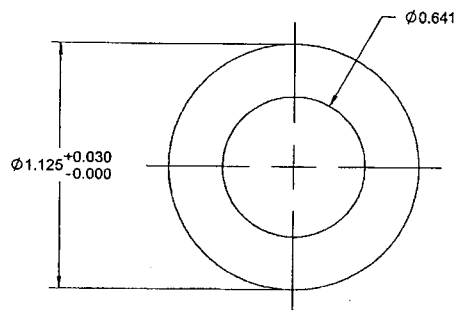
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#71855

D3417-9 WASHER



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2010-09-15
M

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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 3 OF 3
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